

Date: Monday, 7/16/2007 2:48:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 33568	
Estimate Number : 10008	
P.O. Number : <i>N/A</i>	Part Number : D2591
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 33086	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/30/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>17</i> Um: Each
Comment : Est Rev:1 Removed from 9 Digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B0750X02500 ASTM A21 Steel .75"x2.5"



Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick (M1010-B0.750X02.500)
 Batch: *M104286 x 17 prs*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 2.700" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE
receive + inspect for transit damage.

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK
inspect levels

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: *welding*

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Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: D 2591/13

Job Completion

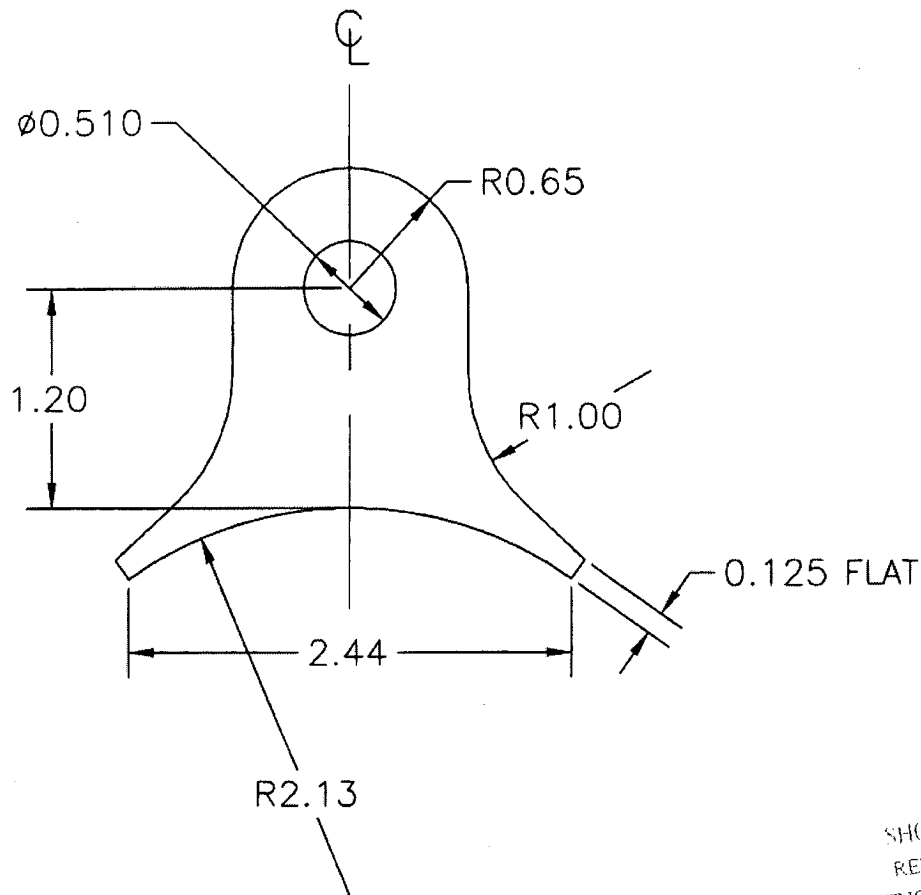


Handwritten: u 57.11.13



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
48.01.21 DS



0.063 # 00.04.05
BREAK ALL SHARP CORNERS ~~0.010~~ TO 0.020
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33568

**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITYPART NUMBERPART NAMEP.O. NUMBER

85

17

D2591

D2591

Lug B34829

Lug B33568

4830

4830

MATERIAL: supplied by DART M1010B07540X02500 B105801

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, November 2, 2007




20 Terry Fox Drive
Vankeek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 16227

Date: Nov 02, 2007

Page: 1

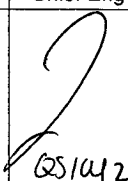

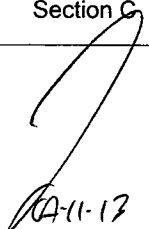
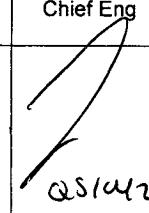
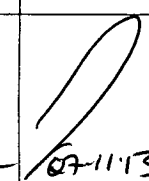
Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4830	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Oct 31, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2591 Lug in steel B34829	Each	90	85	
D2591 Lug in steel B33568	Each	17	17	
Material supplied by DART M1010B07540X02500 B105801				
Please note that 5 pieces were scrapped during machining.				
				
Received by _____		Thank you for your order!		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-13	3.0	Sparks scrap @ Meter. P. 510 were too big.	 QS1042	Scrap & destroy the N.C items returned.	 07/11/13	 07-11-13	 QS1042	 07-11-13

NOTE: Date & initial all entries